Work Order ID 98770

98770

Ship today tuesday March 26th

Friday, March 22, 2013 3:30:13 PM

Item ID: DSI 9464-011 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Skidtube Tuning **Stop** *NS2*

Start Date: 3/22/2013 **Start Qty:** 2.00 *2* **Cust Item ID:**

Required Date: 3/25/2013 **Req'd Qty:** 2.00 *2* **Customer:**

Reference:

Approvals: **Process Plan:** MF **Date:** 13-3-22 **Tooling:** **Date:** **Run Start** *NR1*

QC: **Date:** **SPC (Y/N):** **Date:** **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3955	A								
DSI 9464	B								
100		0.00				2			
100									
DC		0.00							
Document Control	**Memo** Photocopy bluefile &type labels per PPP DSI 9464-011 CHG001								
110	Pick Kit	0.00				2x			
110									
Packaging	**Memo**	0.00							
Packaging									

KSP 13-3-26

SP 13-3-25

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Work Order ID 98770

98770

Friday, March 22, 2013 3:30:13 PM

Item ID: DSI 9464-011 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Skidtube Tuning

Start Date: 3/22/2013 **Start Qty:** 2.00 *2* **Cust Item ID:**

Required Date: 3/25/2013 **Req'd Qty:** 2.00 *2* **Customer:**

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00				2			
120									
QC	**Memo**	0.00							
Quality Control									
130		0.00							
130									
Packaging	**Memo**	0.00							
Packaging	Identify and pack for shipping as per PPP DSI 9464-011 Location:_____ PPP rev:_____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	**Memo**	0.00							
Quality Control									

DAS 13 3 26

(2) DAS 03 9-89 3/3/26

MLJ 13-03-26

MF 13-3-26

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

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- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

Friday, March 22, 2013 3:30:12 PM

Work Order ID: 98770
Parent Item: DSI 9464-011
Parent Item Name: Skidtube Tuning

Start Date: 3/22/2013 **Required Date:** 3/25/2013
Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP RevA: New issue DD verified by:EC 10.04.19 verified byEC IPP Rev:B as per ECN10-553 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3955-041 Doubler Assembly		Manufactured	No			110	Each	5.0000	2	4		SP	
				Location		Loc Qty		Loc Code	1x B98803				
				ST078		5							
				83349		5			3x				
D3955-3 Cover Plate		Manufactured	No			110	Each	4.0000	2	4		SP	
				Location		Loc Qty		Loc Code	2x B98804.				
				ST078		4							
				83350		4			2x				
D3955-5 Plate		Manufactured	No			110	Each	6.0000	2	4		SP	
				Location		Loc Qty		Loc Code					
				ST078		6							
				83352		6			4x				
D3955-7 Plate		Manufactured	No			110	Each	2.0000	6	12		B98771 SP	
				Location		Loc Qty		Loc Code					
				ST078		2							
				93798		2							
D3955-21 Gasket		Manufactured	No			110	Each	8.0000	2	4		SP 13-3-25	
				Location		Loc Qty		Loc Code					
				ST078		8							
				83353		8			4x				

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

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- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
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- ☐ Mislabeled
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Picklist Print

Friday, March 22, 2013 3:30:12 PM

Work Order ID: 98770
Parent Item: DSI 9464-011
Parent Item Name: Skidtube Tuning

Start Date: 3/22/2013 **Required Date:** 3/25/2013
Start Qty: 2.00 **Required Qty:** 2.00

D3955-23
Template

Manufactured | No | 110 | Each | 1.0000 | 2 | 4

B58772 4x SP

Location	Loc Qty	Loc Code	
ST079	1		
83306	1		

GR3212-4-04
Cherry Rivet

Purchased | No | 110 | Each | 4,446.0000 | 38 | 76

M123346 73x

Location	Loc Qty	Loc Code	
ST328	1516		
119075	53		3x.
123265	1463		
st503	2930		
123168	2930		

AN3-5A
Bolt

Purchased | No | 110 | Each | 1,061.0000 | 4 | 8

SP 13-3-25

Location	Loc Qty	Loc Code	
FP001	18		
122800	18		
GA	120		
117423	120		
ST350	22		
120187	22		
ST512	901		
122416	101		8x
124561	800		

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
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Picklist Print

Friday, March 22, 2013 3:30:13 PM

Work Order ID: 98770
Parent Item: DSI 9464-011
Parent Item Name: Skidtube Tuning

Start Date: 3/22/2013 **Required Date:** 3/25/2013
Start Qty: 2.00 **Required Qty:** 2.00

AN3-6A Bolt	Purchased	No		110	Each	463.0000	4	8

Location		Loc Qty	Loc Code
ST350		300	
	124296	300	
ST351		61	
	117441	34	
	121166	13	
	122993	10	
	123831	4	
ST512		102	
	122814	102	

AN3-7A Bolt	Purchased	No		110	Each	130.0000	4	8

Location		Loc Qty	Loc Code
ST351		130	
	123837	18	
	124221	12	
	124805	100	

AN3-10A Bolt	Purchased	No		110	Each	215.0000	4	8

Location		Loc Qty	Loc Code
GA		37	
	122800	37	
ST351		90	
	124221	40	
	124858	50	
ST512		88	
	122800	88	

NAS1149D0332J Washer	Purchased	No		110	Each	382.0000	6	12

Location		Loc Qty	Loc Code
ST294		382	
	122973	382	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
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- Use-as-is ☐
- Work Order Update ☐

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- Skid-tube ☐
- Machining ☐
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- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
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Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
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Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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- ☐ Other _____

Picklist Print

Friday, March 22, 2013 3:30:13 PM

Work Order ID: 98770

Parent Item: DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 3/22/2013 **Required Date:** 3/25/2013

Start Qty: 2.00 **Required Qty:** 2.00

[redacted] Purchased No 110 Each 5,442.0000 [redacted]2 4 SP 3-3-25

Nut

SMD 2

Location		Loc Qty	Loc Code	
FP001		3		
	122141	3		
GA		155		
	122452	155		
ST314		268		
	117885	32		
	119017	55		
	119075	138		
	123265	43		
ST506		5016		
	123900	1068		
	124291	3948		4K

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
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Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
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Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
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Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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- ☐ Other

Part List

Qty -011	Part Number	Description	Weight
X*	DSI 9464-011	SKIDTUBE TUNING KIT	N/A
2	D3955-041	DOUBLER ASSEMBLY	0.25 lb/ 0.11 kg
2	D3955-3	COVER PLATE	0.64 lb/ 0.29 kg
2	D3955-5	0.063" THICK PLATE	0.64 lb/ 0.29 kg
6	D3955-7	0.125" THICK PLATE	1.28 lb/ 0.58 kg
2	D3955-21	GASKET	0.08 lb/ 0.04 kg
2	D3955-23	TEMPLATE	N/A
38	CR3212-4-04	RIVET	N/A
4	AN3-5A	BOLT	N/A
4	AN3-6A	BOLT	N/A
4	AN3-7A	BOLT	N/A
4	AN3-10A	BOLT	N/A
6	NAS1149D0332J	WASHER	N/A
2	MS21042L3	NUT (OR MS21042-3)	N/A

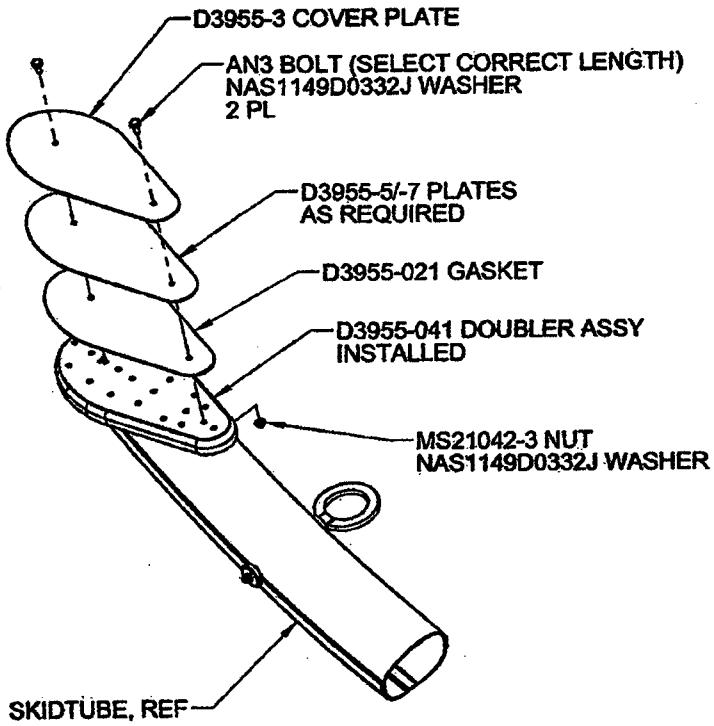


Figure 2

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: _____
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. DSI 9464 — REV. B — SHEET 3 OF 3
CHECKED		TITLE SKIDTUBE TUNING KIT — SCALE NTS
MFG. APPR.	N/A	
APPROVED		
DE APPR.		
DATE	10.04.14	

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Work Order ID 98770

98770

Ship today tuesday March 26th

Friday, March 22, 2013 3:30:13 PM

Item ID: DSI 9464-011 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Skidtube Tuning

Start Date: 3/22/2013 **Start Qty:** 2.00 *2* **Cust Item ID:**

Required Date: 3/25/2013 **Req'd Qty:** 2.00 *2* **Customer:**

Reference:

Approvals: **Process Plan:** MF **Date:** 13-3-22 **Tooling:** **Date:** **Run Start** *NR1*

QC: **Date:** **SPC (Y/N):** **Date:** **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3955	A								
DSI 9464	B								

MLS 13-03-25

ASP

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